

Date: Wednesday, 12/7/2005 12:45:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 25171		
Estimate Number	: 10298		
P.O. Number	: N/A	Part Number	: D25773
This Issue	: 12/7/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2577 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24372	Drawing Revision	: E
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/30/2005
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	50 Um: Each
Comment	: Est: F 02.09.24 Re-format; Incorporated D2577-101/-13 KJ/ RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 00000267

Email or Ship DXF file to vendor

Laser Cut per Dwg D2577 flat pattern D2577-101

Material release note required

2.0	D25773F	Wearplate Aft
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**Comment:** Qty.: 1.0000 U(s)/Unit Total: 50.0000 U(s)

WEAR PLATE FWD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions per template D2577-101T

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-11	4	Took 1 for template. Identify AS D2577-101T (original is missing)	<i>[Signature]</i>	06-01-11	1	<i>[Signature]</i>	<i>[Signature]</i> 06-01-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:40 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 25171

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

SB 06/01/19 49

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job-01-20

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M19174 M19442

LE 06-01-26=49

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-02-03 50

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-03-10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06 02 13 59

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP

M 06 03 13 59

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/13 48

06-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

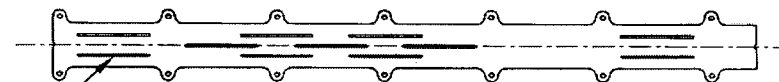
NOTE: Date & initial all entries



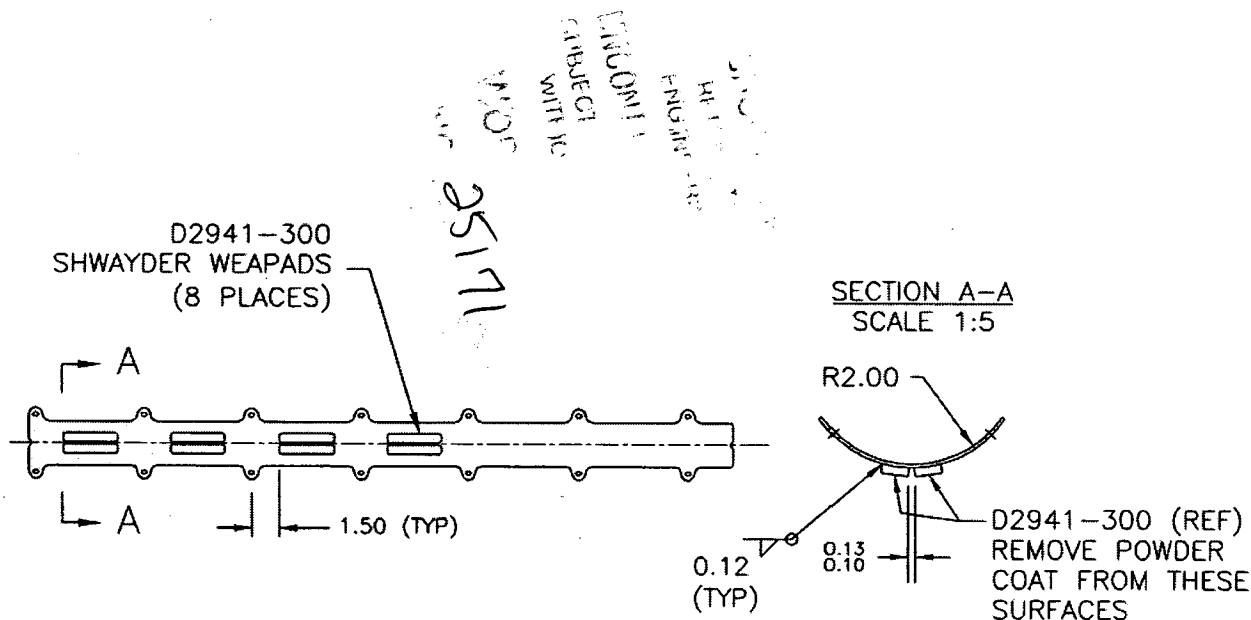
RELEASED
00 04 26 97

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 1 OF 5
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBOUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



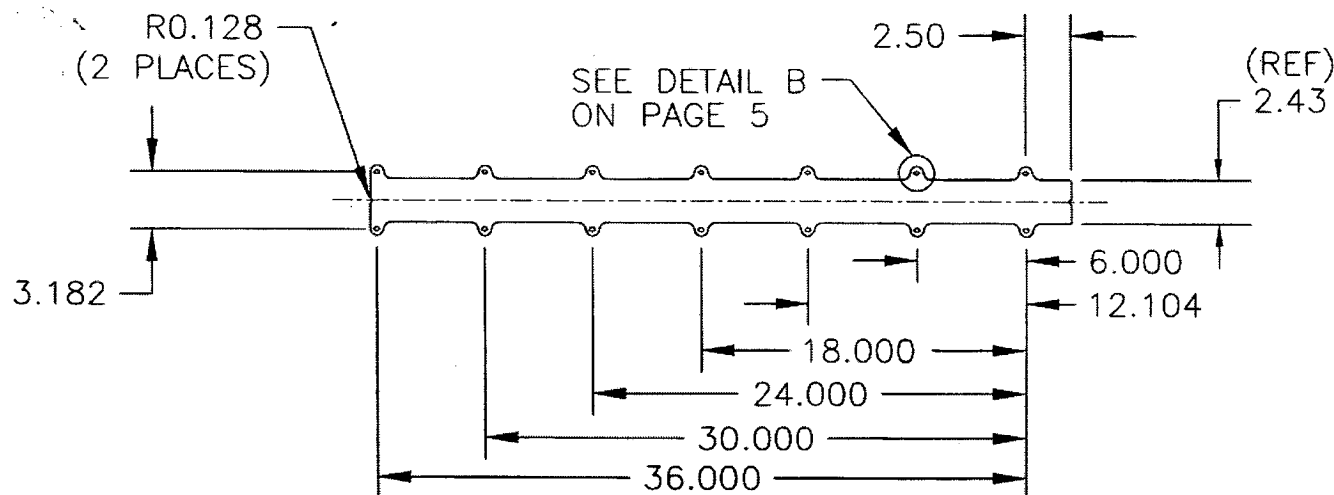
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 2 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10



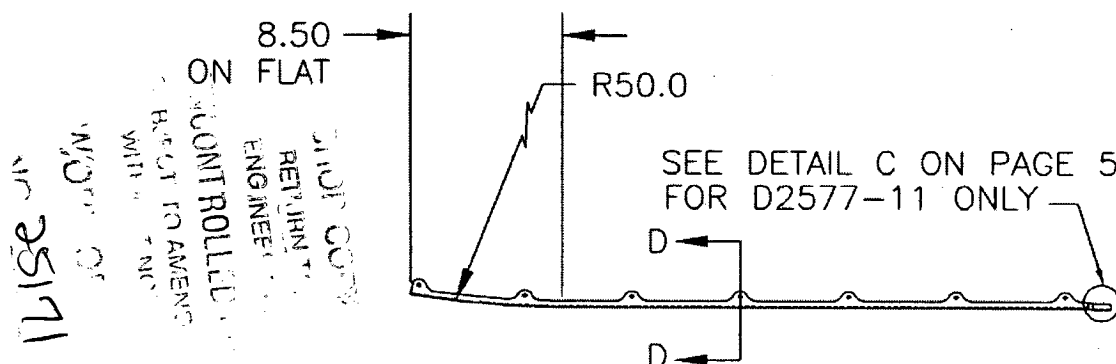
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

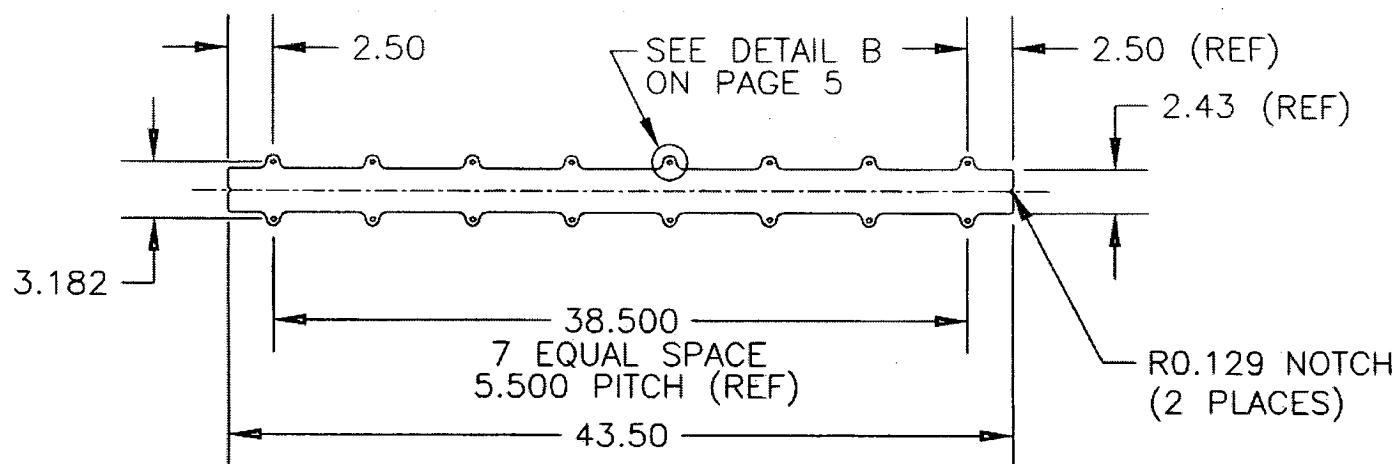
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.26 #1

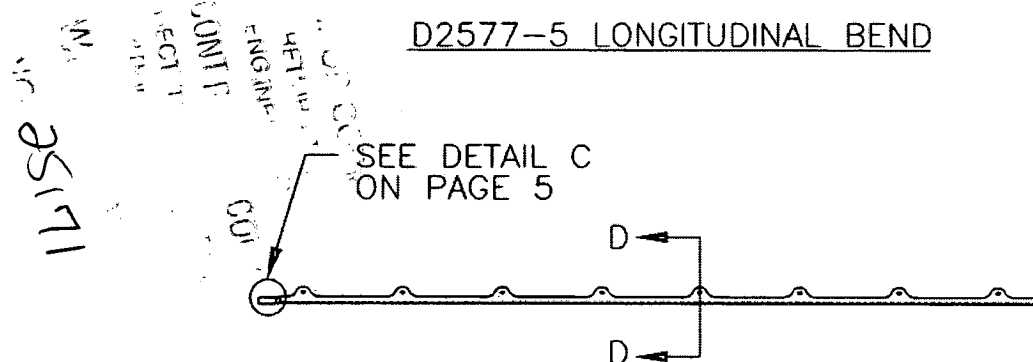


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	CP	APPROVED	CP	HAMKESBURY, ONTARIO, CANADA
DATE	00.09.22	DRAWING NO.	D2577	REV. E
		TITLE	WEARSHOE	SHEET 3 OF 5
		SCALE	1:10	

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

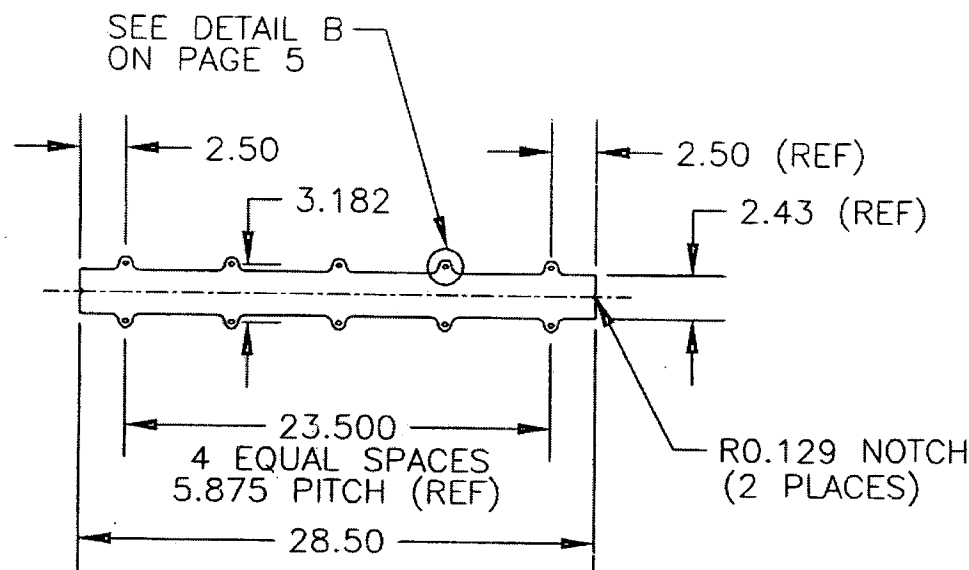
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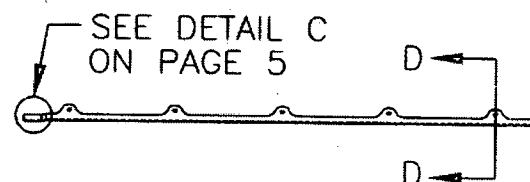
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 4 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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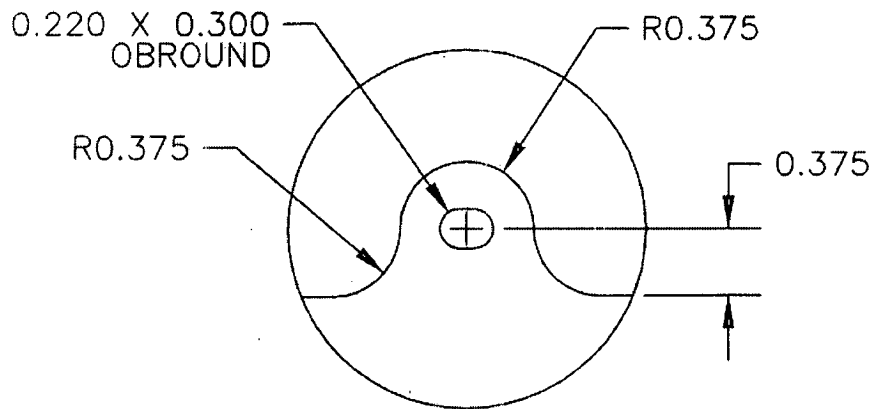
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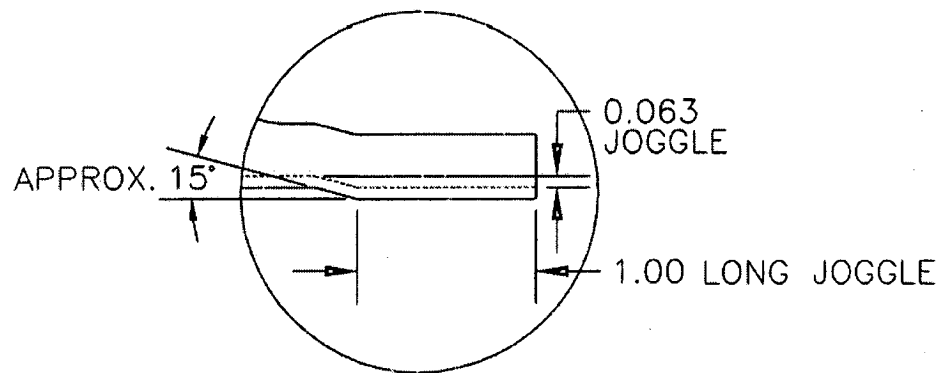
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

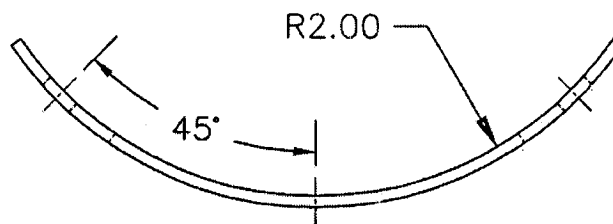
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8859

TEST CERTIFICATE

Ref: S210/22495

CUSTOMER	Wilkinson	P50323 DI001	SPECIFICATION	ASTMA1606 CS Type A	CERTIFICATE No	TC112397
CUSTOMER ON	90-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL ON	480737		DIMENSIONS	0.055" x 48" x Coil	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000										x10000		x100		180°			G.L. =	HRB	()
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=0 (C)=45	(A)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	(A)=C+Mn/8 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/8+Si/24 (D)=
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 So (F)=8"	(B)=90 (D)=(r0+r90+2r45)/4		

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga ns

POA 146, 267, 245

